

Date: Tuesday, 9/25/2007 10:13:36 AM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : REPLACEMENT WINDOW ASSEMBLY |
| Job Number | : 34855 | | |
| Estimate Number | : 11174 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D3290041 |
| This Issue | : 9/25/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3290 UNDER REVIEW |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> | Drawing Revision | : B/C PER ECN# 799 DC |
| Previous Run | : 32285 | Material | : <i>N/A</i> |
| Written By | | Due Date | : 10/2/2007 Qty: <i>15.</i> |
| Checked & Approved By | <i>KJ/JLM</i> | Um: | Each |
| Comment | : Est. B 06.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM | | <i>JL</i> |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: | |
|---------|---|--|----------------------|
| 1.0 | M5052-H32S040 <i>6061T6 - .040</i> | 5052-H32 .040 Sheet | <i>6061T6 - .040</i> |
| | | | |
| | Comment: Qty.: 3.9375 sf(s)/Unit Total : 15.7500 sf(s) 5052-H32 .040 Sheet <i>6061T6 - .040</i> (M5052-H32S040) | | <i>23.625</i> |
| | Batch: <i>M 100723 X6</i> <i>HB 07-10-1</i> <i>M 100742 X6</i> | | |
| 2.0 | WATER JET <i>31.5000</i> | FLOW WATER JET | |
| | | | |
| | Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Dwg Rev: <i>B</i> <i>HB 07-10-1</i> Prog Rev: <i>B</i> | | (14) |
| | 2-Deburr if necessary <i>HB 07-10-1</i> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | <i>HB 07-10-1</i> | |
| | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK | |
| | | <i>HB 07-10-1</i> | |
| | Comment: SECOND CHECK | | <i>cont'd</i> |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 | |
| | | | |
| | Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 | | (14) |
| | | | <i>BL 07-10-02</i> |

Process Sheet

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Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 34855

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation:

6.0 POWDER COATING



POWDER COATING

M105068



(14X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 07/10/02

7.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(14)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 D2126



Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 26.0000 f(s)

Locking Seal

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------|--------|
| 1 | D2126-0780 | Locking Seal | 132619 |

(2)
132619

B

(14)

9.0 D32901



Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------|-------|
| 1 | D3290-1 | Window Frame | 34855 |

2683 SAD 07-10-03

2

2

10.0 D32903



Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Window

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | D3290-3 | Window | 1329568 |

C 7/10/03

7/10/03

11.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 07-10-03

PTD

(X2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 34855

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0 QC5

INSPECT WORK TO CURRENT STEP



En 7/10/03 (2)

Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/03 (2)

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(2) 7/10/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*7/10/03 (2)
7/10/04*

DART

U

| | | | |
|---------------------------|--------|--------------|-------------|
| DART | | Work Order: | |
| Description: Window Frame | | Part Number: | D3290-1 |
| Inspection Dwg: D3290 | Rev: C | | Page 1 of 1 |

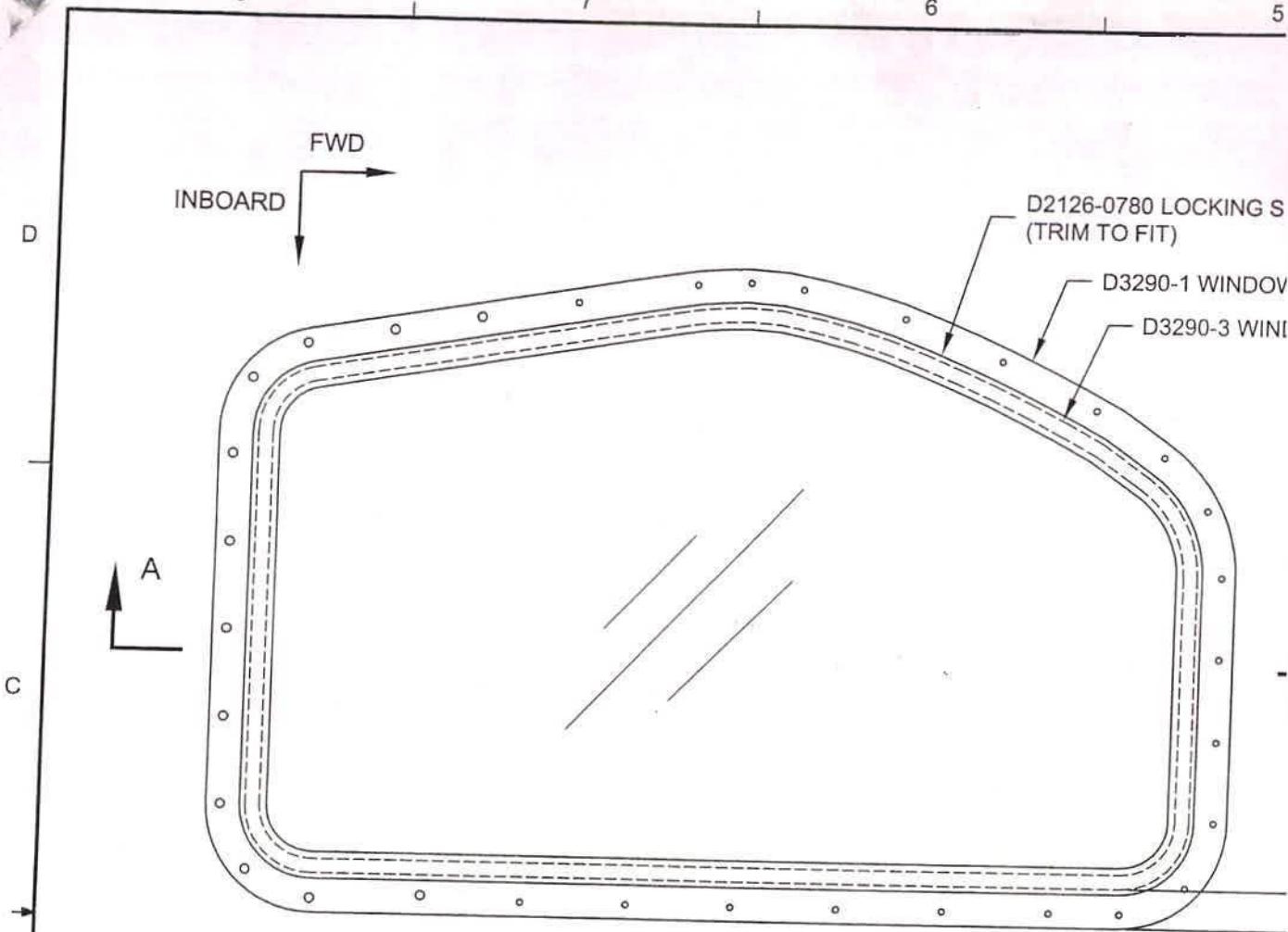
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

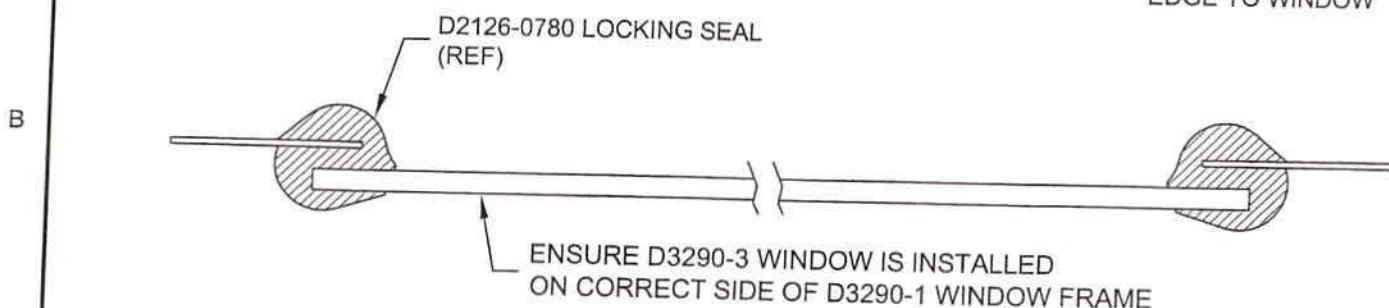
| | | | |
|-----------------|----------------|---------------------|-----------|
| Measured by: KB | Audited by: CS | Prototype Approval: | N/A |
| Date: 07-10-1 | Date: 07/10/01 | | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------|------------|---|
| A | 06.09.19 | New Issue P/O D3290-041 | KJ/JLM | |
| B | 07.07.18 | 13.61 dimension removed | KJ/JLM | |
| C | 07.09.28 | Dwg Rev updated | KJ/EC/DD |  |

8 | 7 | 6 | 5



1.10 (TYP)
DIST. FROM FRAME —
EDGE TO WINDOW



SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

A

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|----------|------|--------------------|--|----------|----|-------------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/10/03 | 11 | | | Split do | | SB 07/10/03 | 2 | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

• NOTE: Date & initial all entries